

Date: Thursday, 7/13/2006 3:38:06 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 27899		
Estimate Number	: 11175		
P.O. Number	: N/A	Part Number	: D22825
This Issue	: 7/13/2006	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 26816	Material	: N/A
Written By	:	Due Date	: 8/15/2006
Checked & Approved By	:	Qty:	100
Comment	: Est Rev:A	Um:	Each
Removed from 9 Digit 05-12-02 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0750	Inventory	
		Comment: Qty.: 0.1891 f(s)/Unit Total : 18.9063 f(s) Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch M103085	J.G 06/09/15
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA189	
		2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	BG 06.09.16 000
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: HAAS #1 Mill Arc as per Dwg D2282	HAAS #1 J.F. 06/11/01 100
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/11/01 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/11/01

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 7/13/2006 3:38:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 27899

Part Number: D22825

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06/11/01

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST35

Box/100 (100)

8.0 DC DOCUMENT CONTROL



(100)

Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/11/01

Job Completion



C Level 11/101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27899
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

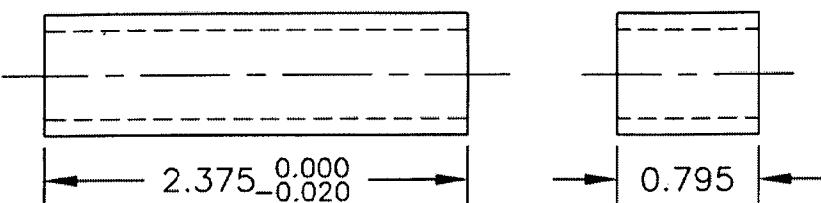
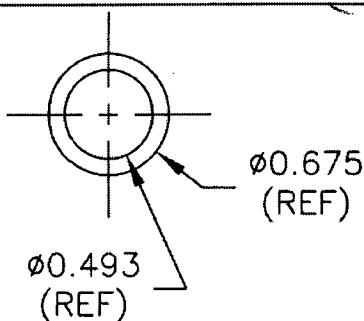
Measured by:	Ba/J.F.	Audited by:	J.G	Prototype Approval:	N/A
Date:	06/10/31	Date:	06/10/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	<i>[Signature]</i>

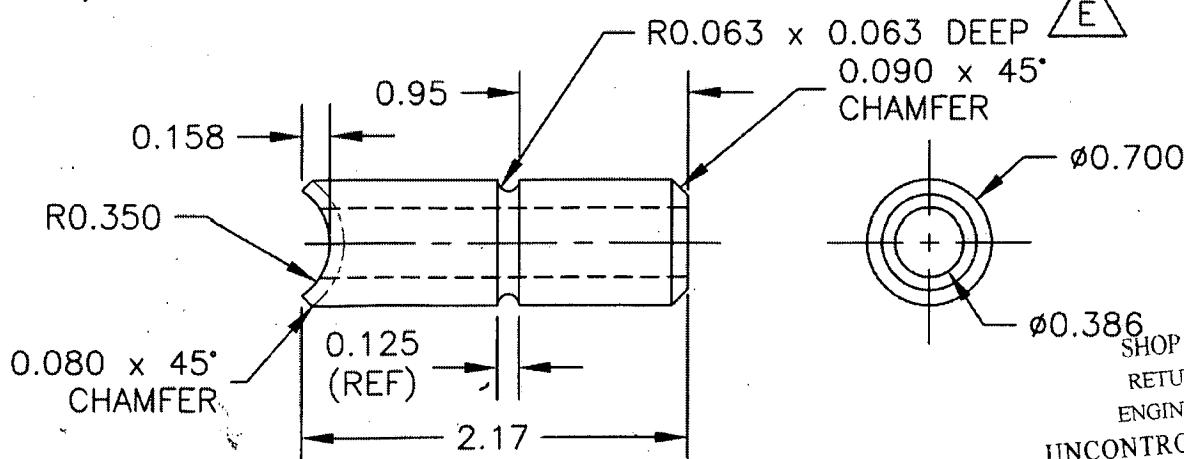
DART

DESIGN BW	DRAWN BY <i>PZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282
DATE 05.06.07	TITLE HANDLE TUBES	REV. E SHEET 1 OF 2 SCALE 1:1

RELEASED
R [redacted]
BS/09/16

**D2282-3**D **D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D **D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

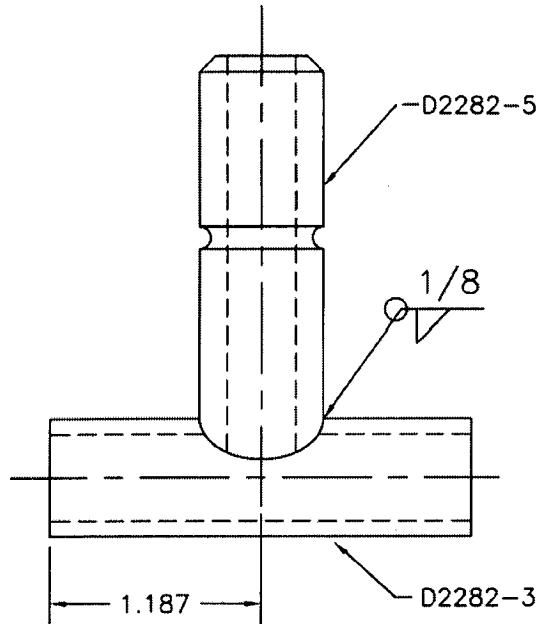
E
 0.386
 Ø0.700
 Ø0.350
 0.090 x 45°
 CHAMFER
 R0.063 x 0.063 DEEP
 0.95
 0.158
 R0.350
 0.125 (REF)
 2.17
 0.080 x 45°
 CHAMFER
 D2282-5

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 WORK ORDER
 NO. 27897

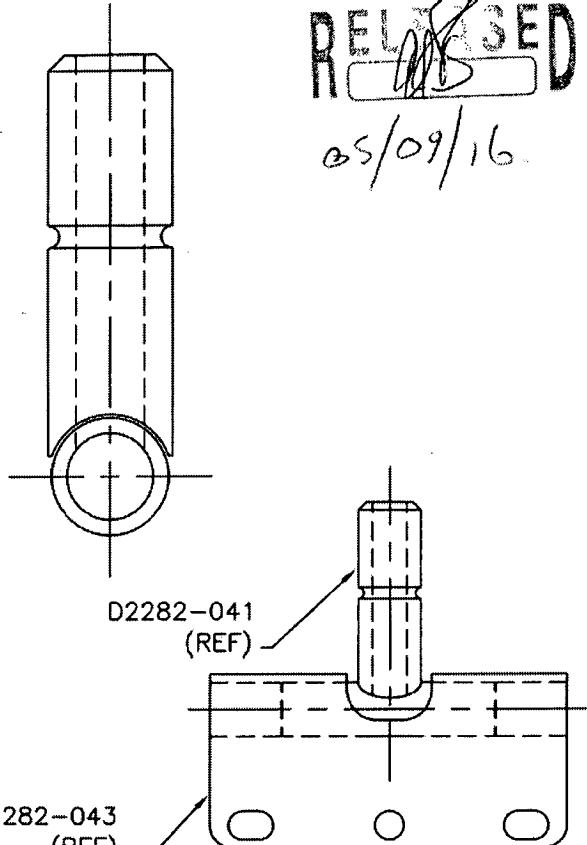
E

DART

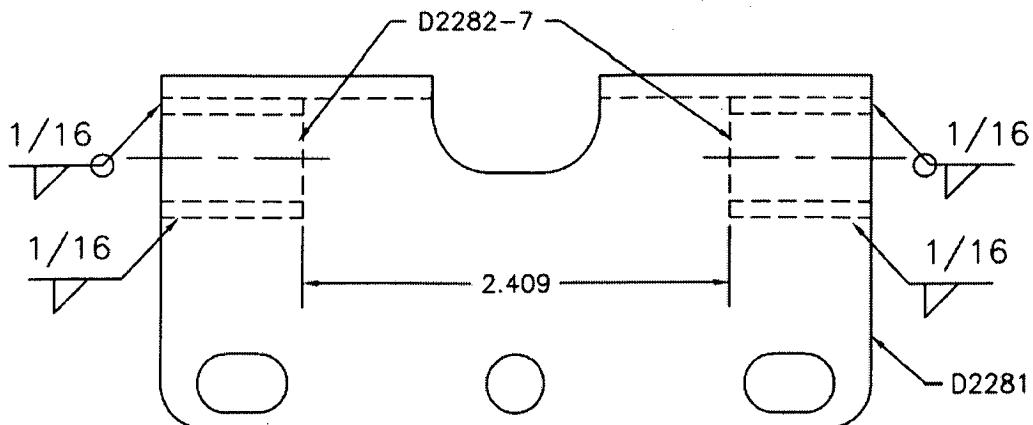
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>MBS</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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